

Work Order ID 130740

130740

Page 1

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *15-03-24* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274-041	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-642-541		CHG005						

N/A MLJ JUN 03 2015

Work Order ID 130740***130740***

Page 2

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

Skidtubes

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding

2- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M127865/M130137

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

5-Drill Aft cap pilot hole using DT8025

6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

Handwritten signature and date: 15-3-20

Handwritten date: 76615-03-30

Handwritten signature and date: DGL 15-4-2.

Work Order ID 130740***130740***

Page 3

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Repl.Skid..High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114	QC5- Inspect part completeness to step on W/O	0.00							
114									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
116	QC10- Inspect visual per QSI004- ground welds	0.00							
116									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									

① 15-04-02

② 150402

1 ② 15-4-2 DBL

Work Order ID 130740***130740***

Page 4

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00				1	0	15.46	JH
130									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>131574</u>								
	Sikaflex expire date: <u>15-10-21</u>								
	Start: Time: <u>8:16 AM</u>								
	Finish: Time:								
	(Adhere for 12 hours)								

1 0 15-4-6 Doc

Work Order ID 130740***130740***

Page 5

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

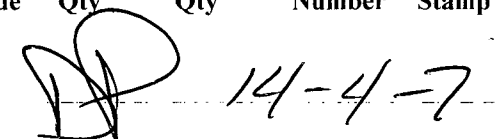
160

QC

Memo

0.00

Quality Control



170

Skidtubes

0.00

170

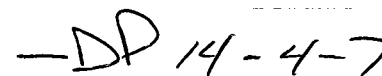
Skidtubes

Memo

0.00

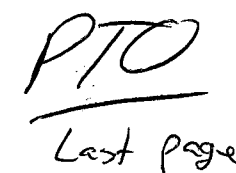
Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding



Work Order ID 130740

130740

Page 6

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

① 13-04-09 PD

190

Skidtubes

0.00

190

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod M30137

3-Grind cross bolt welds flush as per Dwg D3274.
****INSPECT FOR PIN HOLES IN WELD****

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr

7 BE1504-13

15-4-10

Work Order ID 130740***130740***

Page 7

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
210	QC10- Inspect visual per QSI004- ground welds	0.00							
210									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
220	Pressure Wash per QSI005 4.3	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch								

Work Order ID 130740

130740

Page 8

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

230

SprayPaint

Memo

0.00

Spray Painting

Make sure Nut Plate Thread is protected using paint screw.

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: 131846

2- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 131846

240

QC14- Inspect Spray Paint

0.00

240

QC

Memo

0.00

Quality Control

Wing Walk as per dwg QSI005 4.4 Batch 14132039

244

244

HandFinish

Memo

0.00

Hand Finishing

1x of all 13/05/25
DAS 15 9-09

P.T.O.

1x of all 15/05/25

DQA: *at*

Date: 15/06/11



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: *Relly*

Date: 15/06/04

Work Order update only ☐

Work Order: <u>130740</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D206-642-541</u>	Rework ☒	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. <u>15-5052</u>	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-05-22	230	①	Skid tube is light on paint Paint is almost translucent. VERY THIN P.C. operator not re verifying is work	<i>S</i> Q52012 15/05/22	Scuff & re paint as per Q51005	<i>ck</i> 15-05-23	<i>000</i> 15/05/25 G.L.	046 38 9-89 MAY 25 2015
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator ☒									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☒ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Work Order ID 130740

130740

Page 9

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
246	QC3- Inspect Part Finish	0.00							DWG 38 9-89
246									
QC	Memo	0.00							
Quality Control									JUN 02 2015
250		0.00							
250	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing									

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON M122900

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291 M131574

Sikaflex expire date: 12/10

1x of JH 6/05/24

Work Order ID 130740

130740

Page 10

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260									
QC	Memo	0.00							
Quality Control	X Inspect Nut Plate & Inserts								
270		0.00							
270	HAND FINISHING RESOURCE #1								
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads & gaskets as per Dwg D3274.								
	2-Install ring as per Dwg D3274 A/RSikaflex-291 <u>11/13/15</u> Sikaflex expire date: <u>12/16</u>								
	3-Inspect for foreign objects as per QSI 024								
	4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-291 <u>11/13/15</u> Sikaflex expire date: <u>12/16</u>								

1 of 155-25 12/34/15

12 of 15/15/15

Work Order ID 130740

130740

Page 11

Tuesday, March 24, 2015 1:37:14 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280 QC5- Inspect part completeness to step on W/O

0.00

280

QC Memo

0.00

Quality Control

JUN 02 2015

290 Identify as per dwg & Stock Location:

0.00

290

Packaging Memo

0.00

Packaging

300 QC21- Final Inspection - Work Order Release

0.00

300

QC Memo

0.00

Quality Control

MLJ JUN 03 2015

15-6-02

Picklist Print

Tuesday, March 24, 2015 1:37:19 PM

Page 1

Work Order ID: 130740

130740

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC IPP
REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I
14.04.28 AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3274-041BENT

Manufactured

No

110

Each

8.0000

1

D3274-041BENT

Skidtube Assembly 206

**

Location

Loc Qty

Loc Code

LG002

8

128855

8

D4956-15

Manufactured

No

270

Each

17.0000

1

D4956-15

Wearplate Fwd

**

Location

Loc Qty

Loc Code

FP002

17

124078

4

126458

13

D4956-23

Manufactured

No

270

Each

20.0000

1

D4956-23

Wearplate Center Fwd

**

Location

Loc Qty

Loc Code

FP001

13

129679

13

FP002

7

126459

7

Picklist Print

Tuesday, March 24, 2015 1:37:19 PM

Page 2

Work Order ID: 130740

130740

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

D4956-35

Manufactured No

270 Each

28.0000 1 1

D4956-35

Wearplate Aft

**

ll 10/05/25

Location

Loc Qty

Loc Code

FP002

28

124080

9

126460

6

130524

13

X1

D4956-39

Manufactured No

270 Each

16.0000 1 1

D4956-39

Wearplate Center Aft

**

ll 10/05/25

Location

Loc Qty

Loc Code

FP002

16

124081

3

126461

13

V1

D3285-1

Manufactured No

110 Each

42.0000 1 1

D3285-1

Cap

**

BB15-03-30

Location

Loc Qty

Loc Code

LG001

42

121820

15

126290

27

1

D3282-041

Manufactured No

150 Each

2.0000 1 1

D3282-041

Float Web (206L/407)

**

Doc 15.4-6.

Location

Loc Qty

Loc Code

LG002

2

125500

2

1

Tuesday, March 24, 2015 1:37:19 PM

Shop Packet Print

Page 2

Picklist Print

Tuesday, March 24, 2015 1:37:19 PM

Page 3

Work Order ID: 130740

130740

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each 143.0000 , 12 12

D2649

Cross Bolt Spacer

**

BE 15-04-09

Location Loc Qty Loc Code

LG001 143

120508 43

128506 100

D3275-i Manufactured No 190 Each 165.0000 12 12

D3275-1

Cross Bolt Spacer

**

BE 15-04-09

Location Loc Qty Loc Code

LG 126

128974 126

LG001 39

13851 39

CR3212-4-03 Purchased No 250 Each 737.0000 2 2

CR3212-4-03

Cherry Rivet

**

10/05/25

Location Loc Qty Loc Code

CCK004 700

119017 700

LG001 26

m123265 26

ST320 11

m114859 11

D3415-041 Manufactured No 250 Each 40.0000 1 1

D3415-041

Nut Plate

**

10/05/25

Location Loc Qty Loc Code

ST037 40

121836 40

Tuesday, March 24, 2015 1:37:20 PM

Shop Packet Print

Page 3

Picklist Print

Page 4

Tuesday, March 24, 2015 1:37:20 PM

Work Order ID: 130740

130740

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3 CCR264SS-3-03 Purchased No

250 Each 31.0000 2 2

CCR264SS3-3

Cherry Rivet

**

ll 15/05/25

Location Loc Qty Loc Code

FP001 24

m126333 24

ST321 7

113973 7

X2

ALS4-1032-130 AELS4-1032-130 Purchased No

250 Each 1,652.000 78 78

AIS4-1032-130

Rivnut

**

ll 15/05/25

Location Loc Qty Loc Code

CA 1511

M128649 1511

st549 141

110511 10

M128649 131

X78

D3537-3 Manufactured No

270 Each 32.0000 1 1

D3537-3

Wearpad

**

ll 15/05/25

Location Loc Qty Loc Code

FG 8

86237 8

FP001 24

120646 24

X1

Tuesday, March 24, 2015 1:37:20 PM

Shop Packet Print

Page 4

Picklist Print

Tuesday, March 24, 2015 1:37:20 PM

Work Order ID: 130740

130740

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

270

Each

67.0000

9

9

D3537-1

Wearpad

**

HL 15/05/25

Location

Loc Qty

Loc Code

FG

18

B130493

x9

79833

8

88562

10

FP001

17

126306

1

128225

3

129514

13

PKG12

32

125911

29

90197

3

NAS1149C0332R

Purchased

No

270

Each

6,320.000

80

80

NAS1149C0332R

WASHER

**

HL 15/05/25

Location

Loc Qty

Loc Code

FP001

2174

M132262

x80

123248

34

m130325

2140

ST260a

3000

m131697

3000

ST271

1146

m131340

24

m131618

1122

Picklist Print

Tuesday, March 24, 2015 1:37:20 PM

Page 6

Work Order ID: 130740

130740

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0463R

Purchased

No

270

Each

377.0000

1

1

NAS1149C0463R

Washer

**

all 15/08/25

Location

Loc Qty

Loc Code

FP001

91

m127306

91

X1

ST271

286

m128401

286

D3672-1

Manufactured

No

270

Each

842.0000

2

2

D3672-1

Washer, Phenolic

**

all 15/08/27

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

252

113581

252

ST055

580

120116

80

127322

500

X2

AN3C4A

Purchased

No

270

Each

1,817.000

80

80

AN3C4A

Bolt

**

all 15/08/25

Location

Loc Qty

Loc Code

FG

20

122814

20

FP001

920

M131803

920

ST338a

4

M131320

4

ST350

873

M131420

873

M132189

X80

Tuesday, March 24, 2015 1:37:20 PM

Shop Packet Print

Page 6

Picklist Print

Page 7

Tuesday, March 24, 2015 1:37:20 PM

Work Order ID: 130740

130740

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

270

Each

90.0000

1

1

AN4C5A

Bolt

**

HL 15/05/25

Location

Loc Qty

Loc Code

FP001

10

M128403

10

ST345

40

M130466

40

ST346

40

131677

40

XL

D2646

Manufactured

No

270

Each

63.0000

1

1

D2646

Aft Cap

**

HL 15/05/25

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

59

103306

1

114495

6

127924

13

128761

39

XL

D3413-1

Manufactured

No

270

Each

46.0000

1

1

D3413-1

O-Ring

**

HL 15/05/25

Location

Loc Qty

Loc Code

st530

46

110715

8

114489

4

125157

12

127411

6

129085

16

XL

Tuesday, March 24, 2015 1:37:21 PM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2800-1-240	EXTRUSION
1	1	D2846	AFT CAP
12	12	D2849	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4956-15	WEARSHOE
1	1	D4956-23	WEARSHOE
1	1	D4956-35	WEARSHOE
1	1	D4956-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3CA4	BOLT
1	1	AN4CSA	BOLT
1	1	AN860C416	WASHER
80	80	AN860C10L	WASHER
2	2	CCR284SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

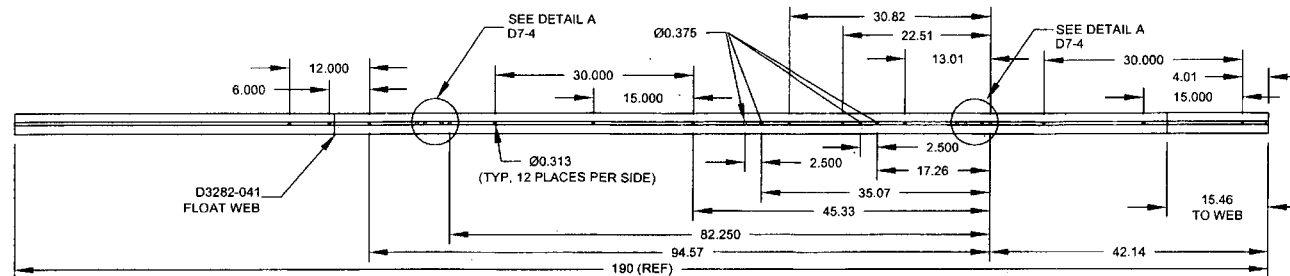
1. MATERIAL: N/A
2. FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF. 4.2 1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: 20.8 LBS
8. WELDING TO BE DONE PER DART QSI 004.
9. ALL HOLES DRILLED ON CENTERLINES.
10. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/-291.
13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.



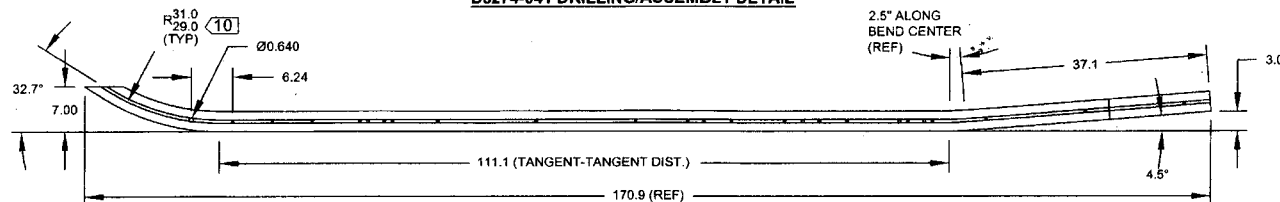
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-042 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE EXPRESS COPIES FOR THAT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD	

130740 MWS
15-03-24

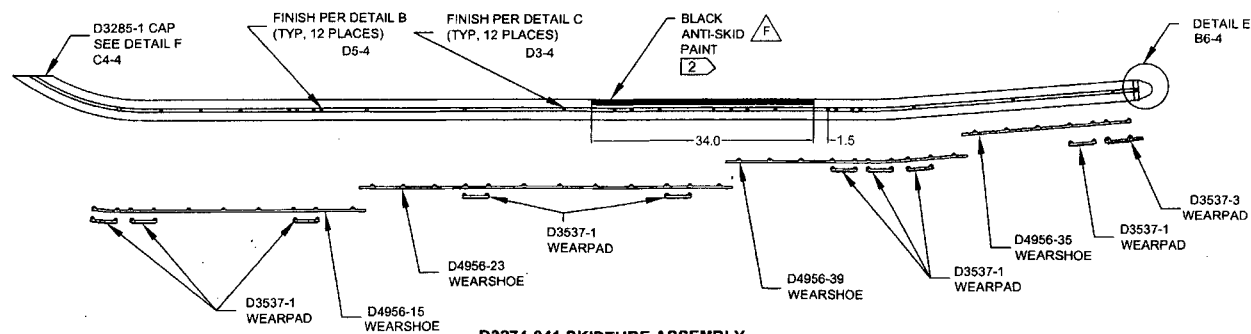
RELEASED
2014-05-26
[Signature]



D3274-041 DRILLING/ASSEMBLY DETAIL



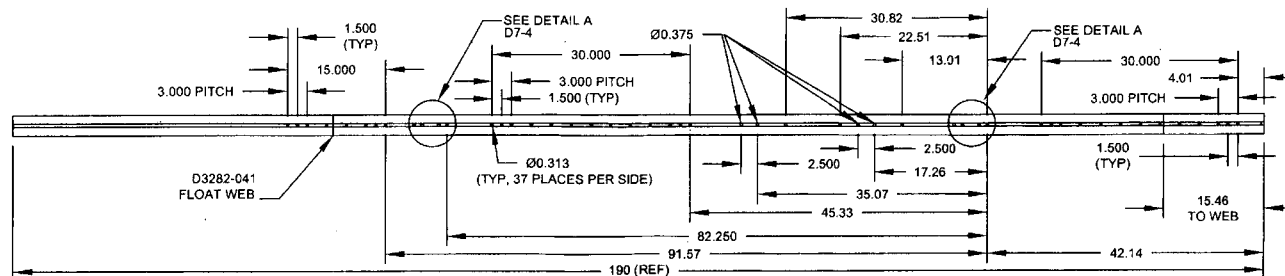
D3274-041 BEND/DRILLING DETAIL



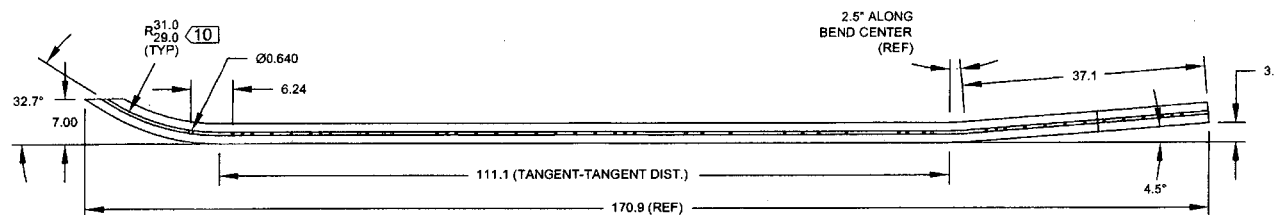
**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

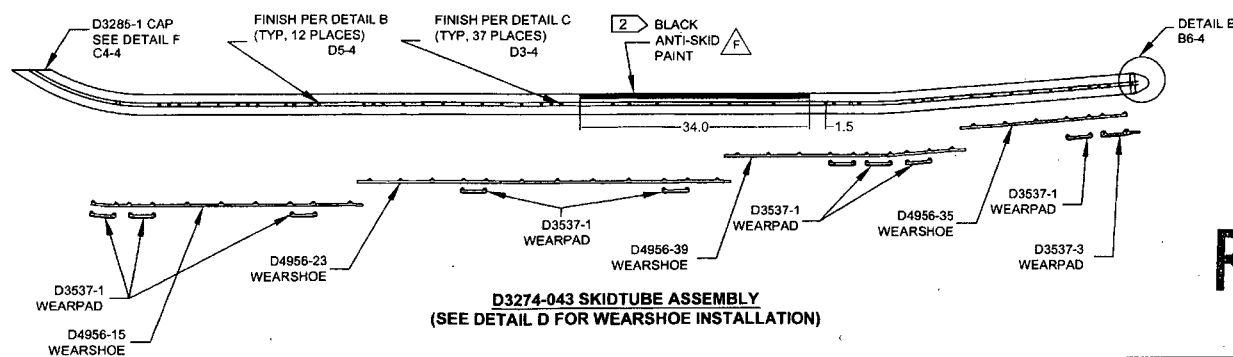
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

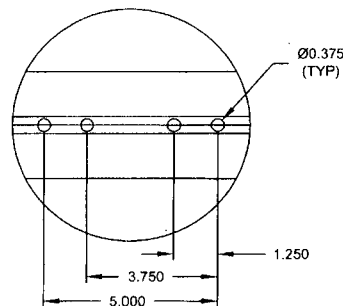


**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

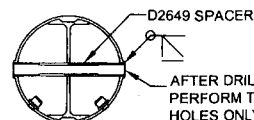
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	DB	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	4.04.15
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD	

DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

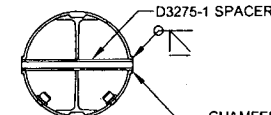
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313x0.75 DEEP

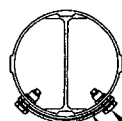
DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



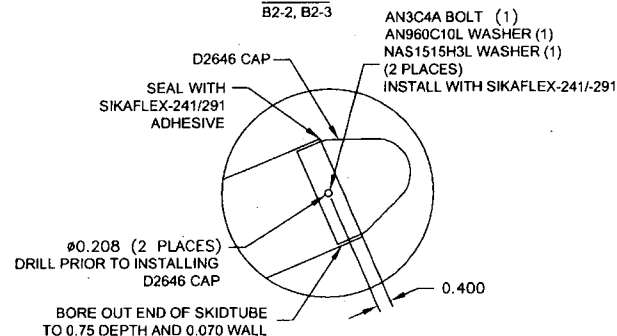
CHAMFER 0.030x45°
(TYP)

DETAIL D
A4-2, A4-3

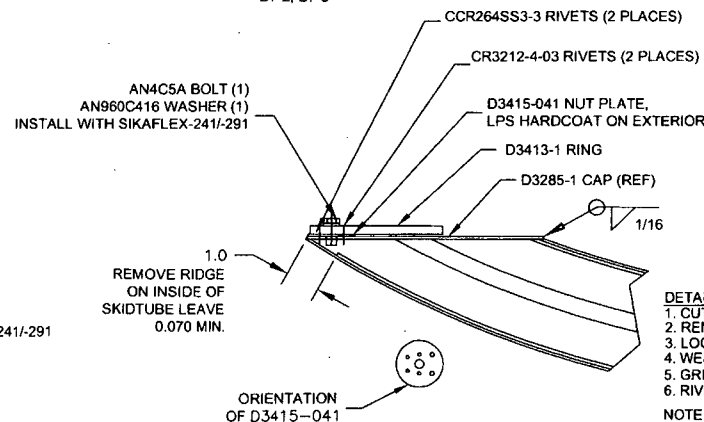


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASE
2014-05-26

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE COPIED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	

DQA:

Date: 15/06/08



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/06/04

Work Order update only ☐

Work Order: <u>130740</u> Part No. <u>D206-642-541</u> NCR No. <u>15-5053</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☒ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
---	---	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15/4/9	170	1	APT bend is 3.40" high (avg is 3.0")	DAS 12 989 15/4/9	Acceptable. Higher aft end results in lower bending moment in tube.	DAS 12 989 15/4/9	 15-4-9	PD 15.04.09
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☒ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	---	---	--	--